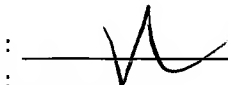
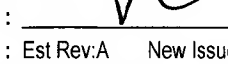


Date: Tuesday, 02/10/2007 12:59:25 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 34967	
Estimate Number : 12884	
P.O. Number : N/A	Part Number : D3560044
This Issue : 02/10/2007 S.O. No. : JLA	Drawing Number : D3560 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 34477	Material : N/A
Written By : 	Due Date : 09/10/2007 Qty: 5 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A New Issue 07.05.24 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
	Comment: LARGE FABRICATION RESOURCE 1 PULL FROM STK: <i>PL 07.10.03</i> 5		
2.0	D3560044	ARM WELDMENT	
			
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) ARM WELDMENT <i>3 32448</i> <i>PL 07.10.03</i> 5		
3.0	D35921	PLATE	
			
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PLATE <i>3 34260</i> <i>PL 07.10.03</i> 5		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
	Comment: LARGE FABRICATION RESOURCE 1 1-Weld assembly as per dwg D3560 <i>PL 07.10.03</i> 5		
5.0	QC5	INSPECT WORK TO CURRENT STEP	
			
	Comment: INSPECT WORK TO CURRENT STEP <i>02/10/04 (5)</i>		
6.0	QC9	VISUAL WELDING INSPECTION	
			
	Comment: VISUAL WELDING INSPECTION <i>10 07.10.04 (5)</i>		

Date: Tuesday, 02/10/2007 12:59:25 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34967

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DE 02-10-04 5

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

/

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *UHA*

DE 02-10-04 5

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

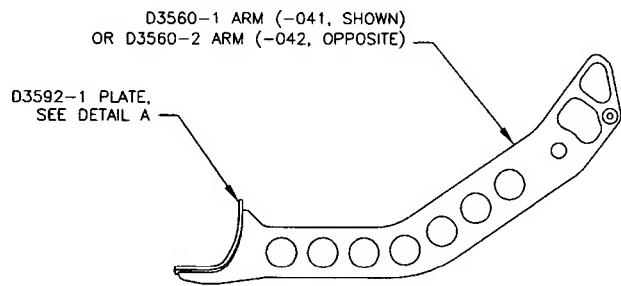
(5) 02/10/05

Job Completion

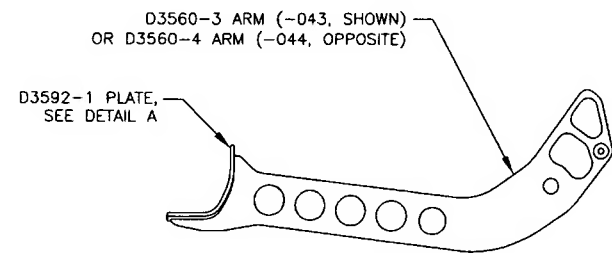


UHA 02/10/05

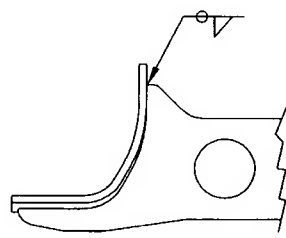
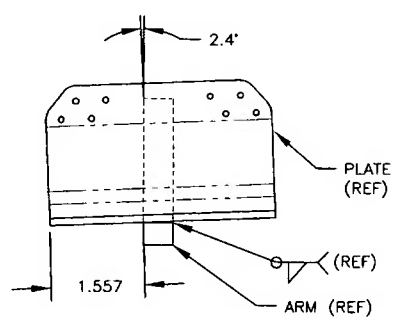
6962501m



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

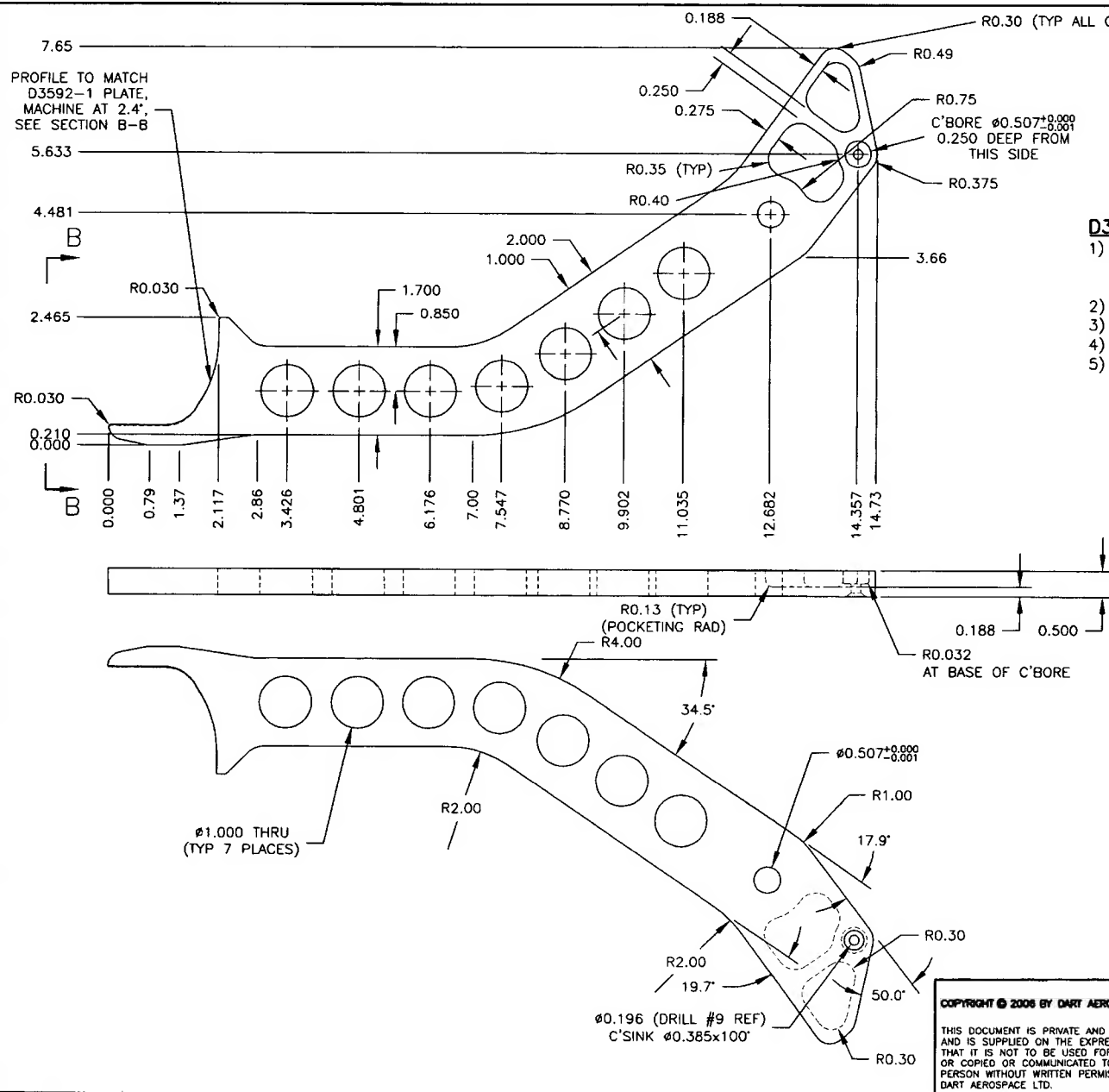
- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

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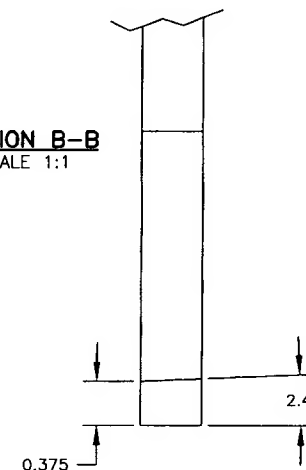
C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	<i>q</i>	DRAWN BY <i>q</i>
CHECKED	<i>q</i>	APPROVED <i>q</i>
DATE	07.06.19	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. C
		SHEET 1 OF 3
		SCALE 1:4



D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B
SCALE 1:1

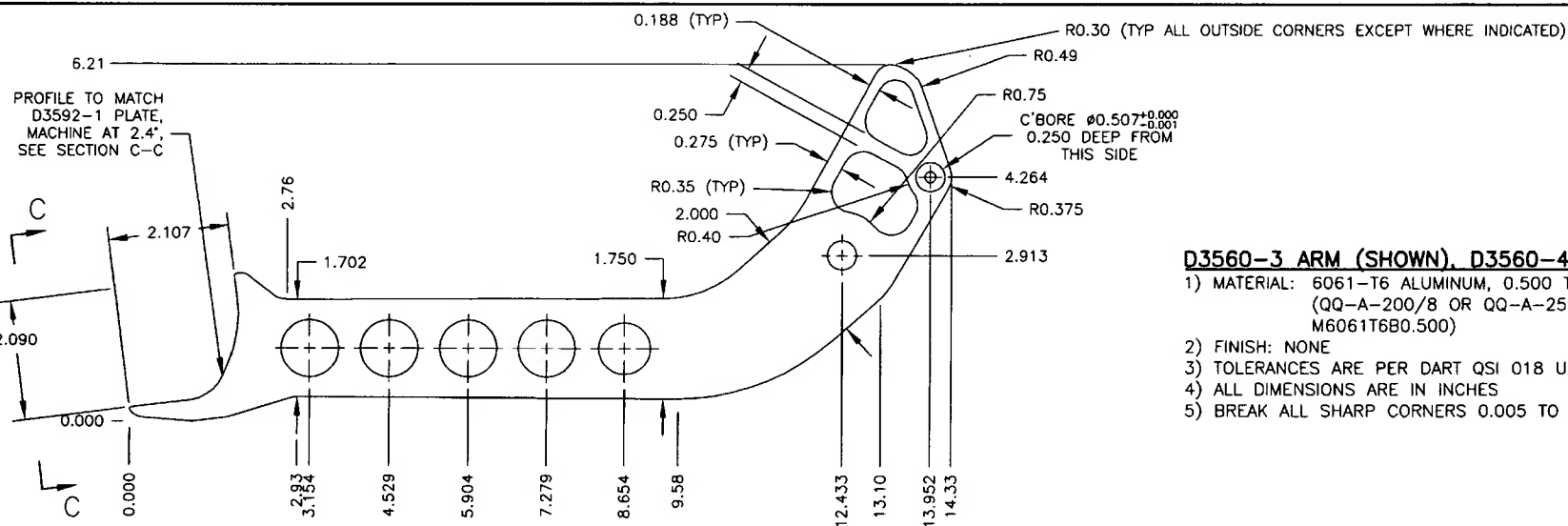


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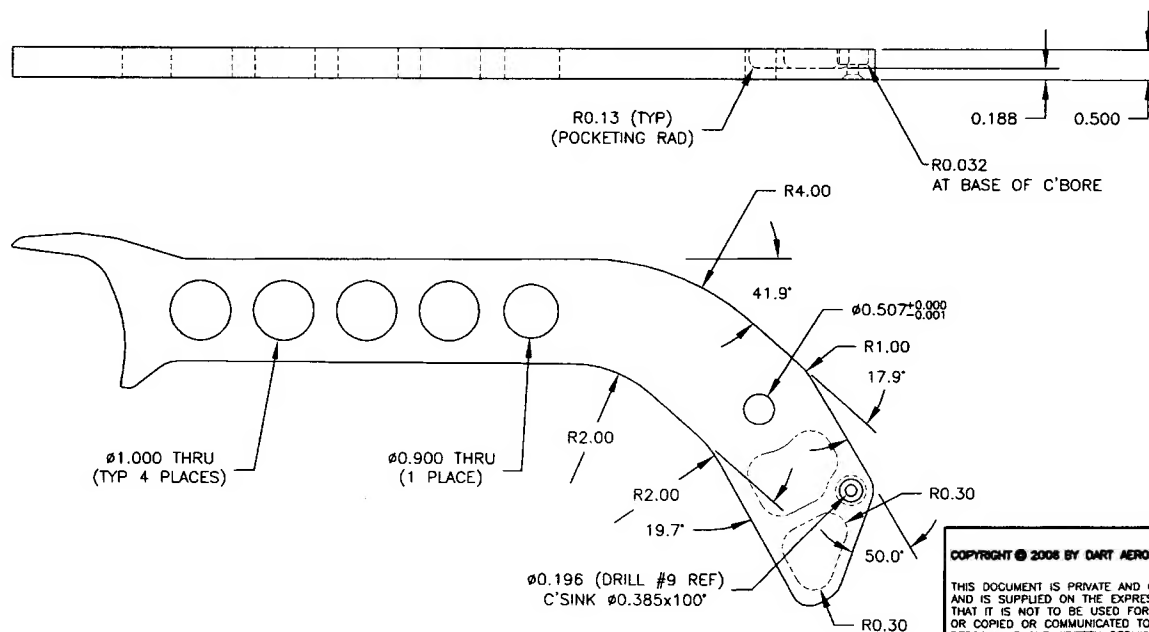
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DESIGN	q	DRAWN BY	q	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	h	APPROVED	h	DRAWING NO. D3560	REV. C
DATE	07.06.19	TITLE	ARM WELDMENT	SHEET 2 OF 3	SCALE 1:2

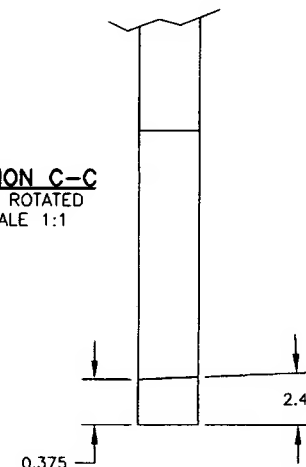


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



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DESIGN	49	DRAWN BY	49	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	49	APPROVED	49	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 3 OF 3
				SCALE	1:2